

535

DART AEROSPACE LTD	Work Order:	23934
Description: Saddle billet	Part Number:	D6101-001
Drawing: D6101 Rev. A	Qty:	50


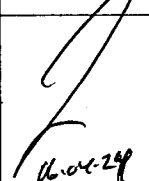

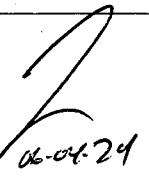
Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	AP	08/02/05	50
2	PURCHASING	Issue P/O: 2008440 2008787 a) Description: Alluminum billet b) 6.00" x 6.250" x 2.00" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 6.00" length e) Material: 7075-T7351 (QQ-A-250/12) Material certification required	AP	05/10/07	50
3	RECEIVING	Receive & Inspect for transit damage Ensure certification are attached	PL	05/12/30	50
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	BC	06.04.24	49
5	STORES	Identify & stock	J	06.04.24	49
6	EXPEDITING	Close W/O Cost / part	Inspect Level 21	07.04.13	49


Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

EC 01.05.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date.	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 23934		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.04.24	4	Wrong grain direction. 1 blank used in production - Part was destroyed		Blanks may be used for production with minor changes to machining process. The 49 blanks have been separated from similar material. Notify supplier.	BG 06.04.24			

Part No: D6101-001 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 09.01.07

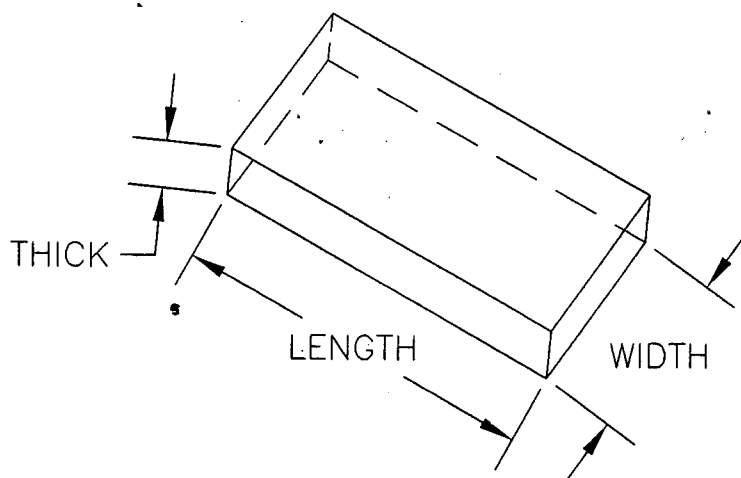
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>S</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *#*



SHOP COPY
RETURN TO
ENGINEERING
UNQUOTE COPY
SUBMIT FOR
WITHOUT

WORK ORDER

NO. 23934

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 02, 2005
01:38 pm

Work Order No	: 0023934	Department Code:	
Project Name	: D6101-001	Burden Flags	: NNNNNNN
Project For	: WK535	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6101-001	Invoice Number	:
Description	: 7075-T7351 2X6X6.25	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 50	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-02-05		
Est Finish Date	: 08-31-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

Alcoa Inc.

Ship From: RIVERDALE, IA.

426542
Ship Date

155001
B.L. No.

Invoice No.

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Page 1

2005-06-06

77266

15970

DS-85756-1

P.O. No./Govt Contract No.

Customer

CC5442

C&B-WALLINGFORD

Mark J. Kraker

Kenton P. Young

Mark J Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DRIVE
WALLINGFORD, CT 06492

[illegible]

2.000 IN TK X 48.500 IN W X 144.500 IN LN (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, US1 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED {{ P/N 091548-8 }}. PER AMS-QQ-A-250/12 AND AMS-STD-
2154 & EXCEPT MARKING MMS159 REV N & EXCEPT
MARKING AMS4078 REV F & EXCEPT MARKING
ASTMB209 REV 04 & BSS7055 REV A US1 PER PS21211
REV J MARKING PER PS16120 REV G ULTRASONIC
INSPECTION PE ASTMB594 REV 02 ((MARKED))
INTERLEAVED MAX GROSS SKID WGT: 5000 LB QUAN TOL +/-
40 % US1 CL A 3 MM CQR 0148581 REV 03 CUST REQ 05-06-
05 *** W/E 05-06-11 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	294961	402991	4309	3	PC	
2	294962	402991	4301	3	PC	
			8610	6		

Notes for CQR: 0148581.3

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12. THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I. PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.

CQR: 0148581.3 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T7351	Long Transv.	Max	68.9	
		Min	57.0	6
T7351	Elec. Cond. (EC) % MIN	38.0	PCT	

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 7075	Max	.40	.50	2.0	.30	2.9	.28	6.1	.20	.05	.15	
	Min			1.2		2.1	.18	5.1				REMAIN

CERTIFIED INSPECTION REPORT

Alcoa Inc.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

426542
Ship Date

2005-06-06

P.O. No./Govt Contract No.

CC5442

155001
B.L. No.

77266

PITTSBURGH, PA

DAVENP

Ship From: RIVERL

Invoice No.

15970

Alcoa No. Item

DS-85756-1

Customer

C&B-WALLINGFORD

Lot: 402991 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No.	UTS	TYS	EL4D
T7351	Long Transv.	3	Max 71.8 KSI	61.4 KSI	PCT 10.9
T7351	Elect Cond	%IACS	Min 71.7	61.3	10.8
			40.8 40.8 41.1	PCT	

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9767014	Actuals	.08	.26	1.7	.03	2.5	.19	5.7	.02

